

Work Order ID 59985

Tuesday, June 22, 2010 10:17:48 AM



Page 1

Item ID: D2989-3

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 6/22/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: 11

Date: 10-6-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 cut D2989-3 to length using DT9441 template and cut 45 degree as per dwg D2989 2- remove identification markings 3- deburr

SAD 10-06-28

2

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/06/29

2

120

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD 10-06-28

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/29 JG

10/06/29

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Picklist Print

Tuesday, June 22, 2010 10:17:51 AM

Page 1

Work Order ID: 59985

Parent Item: D2989-3

Parent Item Name: Rib



Start Date: 6/22/2010

Required Date: 7/26/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3166-3		Manufactured	No			100	Each	9.2838	0.08	0.168421			
---------	--	--------------	----	--	--	-----	------	--------	------	----------	--	--	--



Basket Hoop



SAD 10-06-28

Location

Loc Qty

Loc Code

WA

9.283751053

55697

2.1053E-05

57504

3.28373

59266

6

0.1684

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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59985
BS10-6-22

- NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D327-3 (NOW INSTALLED ON D3838 DWG); D2989-9/-10 (NOW ON D3838 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED	AJS	D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.09.24		

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

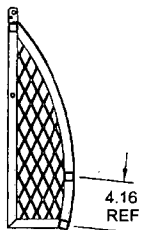
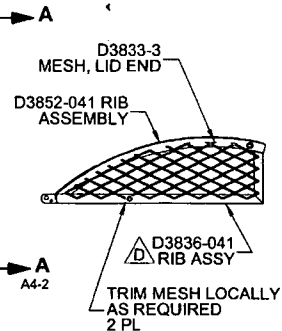
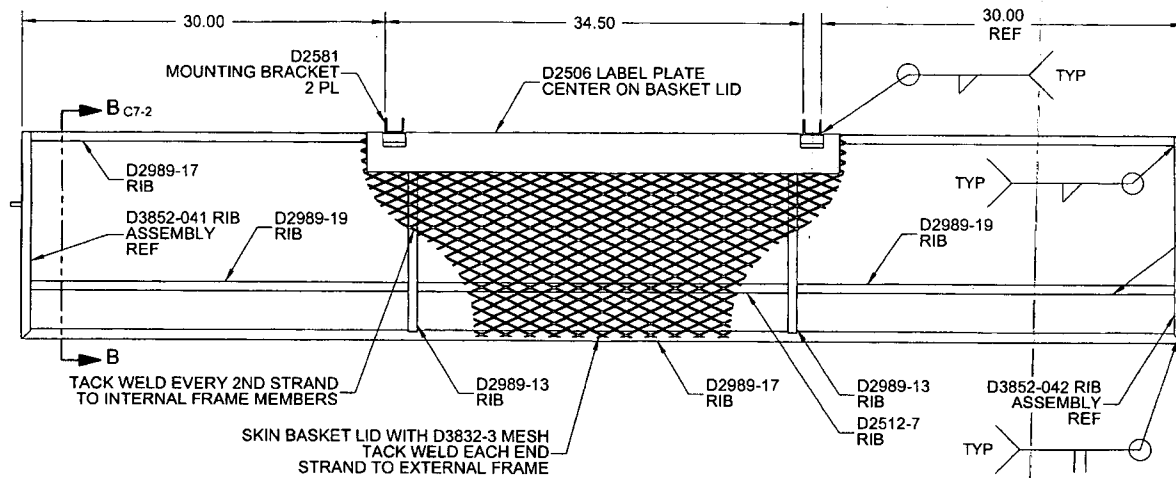
3

2

1

SECTION B-B

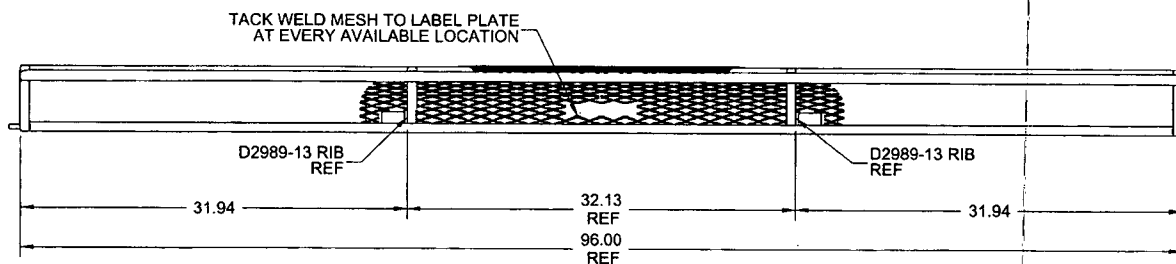
D7-2

4.16
REFD3833-3
MESH, LID ENDD3852-041 RIB
ASSEMBLYD3836-041
RIB ASSYTRIM MESH LOCALLY
AS REQUIRED
2 PLD2581
MOUNTING BRACKET
2 PLD2506 LABEL PLATE
CENTER ON BASKET LID

B C7-2

D2989-17
RIBD3852-041 RIB
ASSEMBLY
REFD2989-19
RIBTACK WELD EVERY 2ND STRAND
TO INTERNAL FRAME MEMBERSSKIN BASKET LID WITH D3832-3 MESH
TACK WELD EACH END
STRAND TO EXTERNAL FRAMED2989-13
RIBD2989-17
RIBD2989-13
RIBD2512-7
RIBD3852-042 RIB
ASSEMBLY
REF

TYP

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKID'DBLACK ANTI-SKID
PAINT THIS SECTIONTACK WELD MESH TO LABEL PLATE
AT EVERY AVAILABLE LOCATIOND2989-13 RIB
REFD2989-13 RIB
REF

31.94

32.13
REF

31.94

96.00
REF

D2989-041 BASKET LID ASSEMBLY (MESH SHOWN LOCALLY FOR CLARITY)



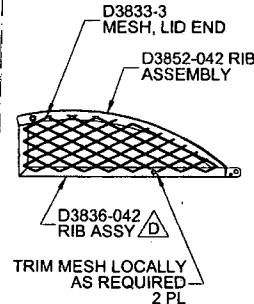
2 PL

FILL NOTCH
WITH WELD
9 PL

VIEW A:A

B8-2

w/o 59985

D3833-3
MESH, LID ENDD3852-042 RIB
ASSEMBLYD3836-042
RIB ASSYTRIM MESH LOCALLY
AS REQUIRED
2 PLRELEASED
08/11/84

DESIGN	DS
DRAWN	
CHECKED	
MFG. APPR.	
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DE APPR.	
DATE	08.09.24

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. D
D2989	SHEET 2 OF 5
TITLE	SCALE
BASKET LID ASSEMBLY	NTS

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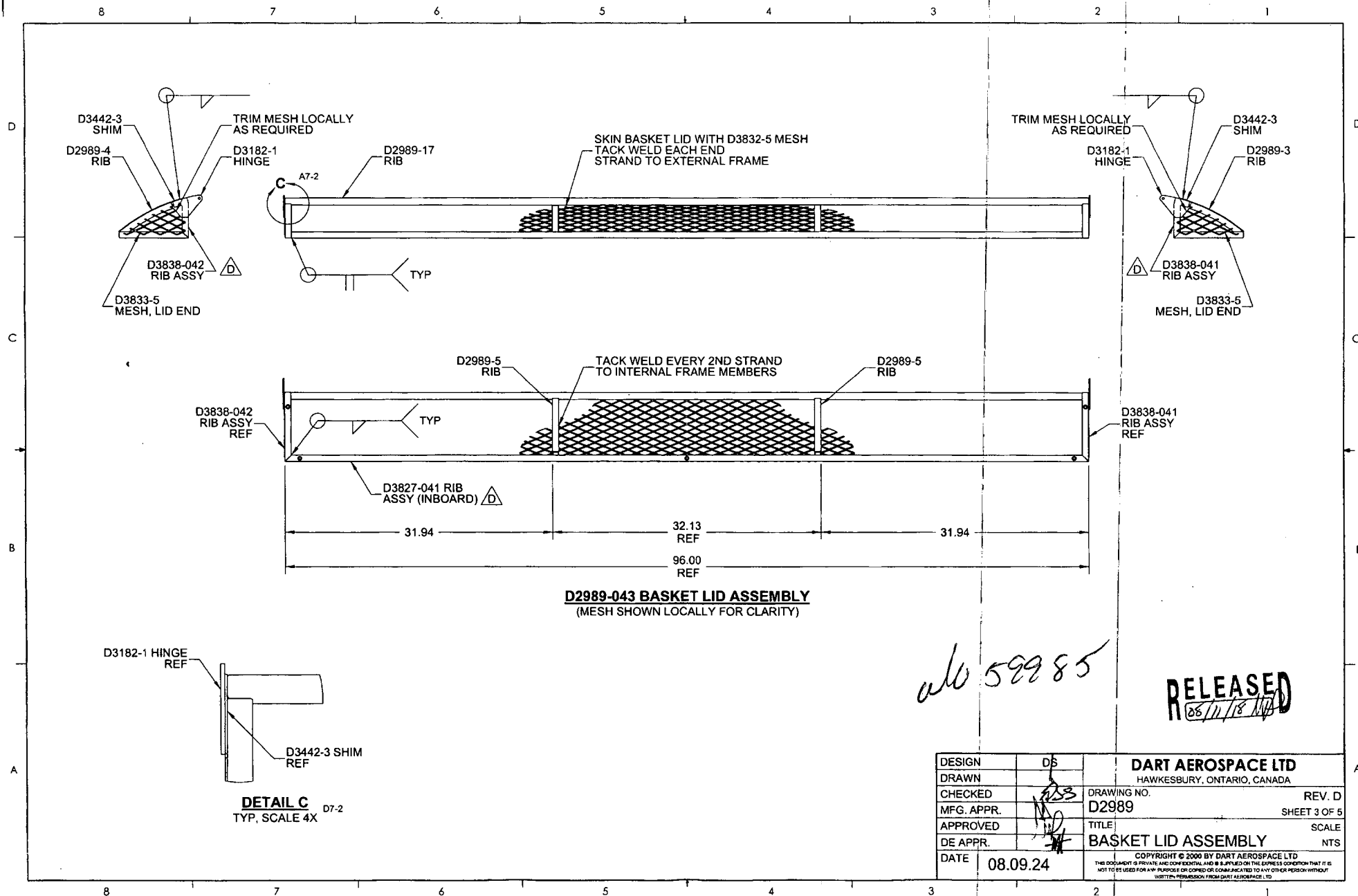
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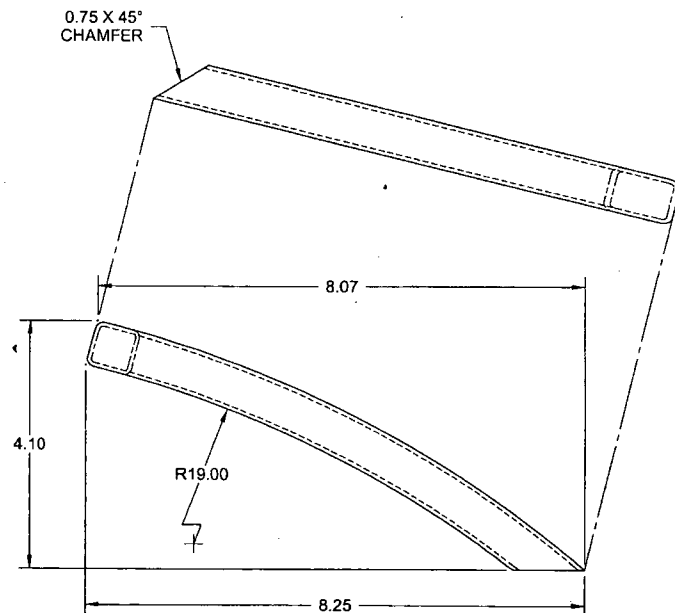
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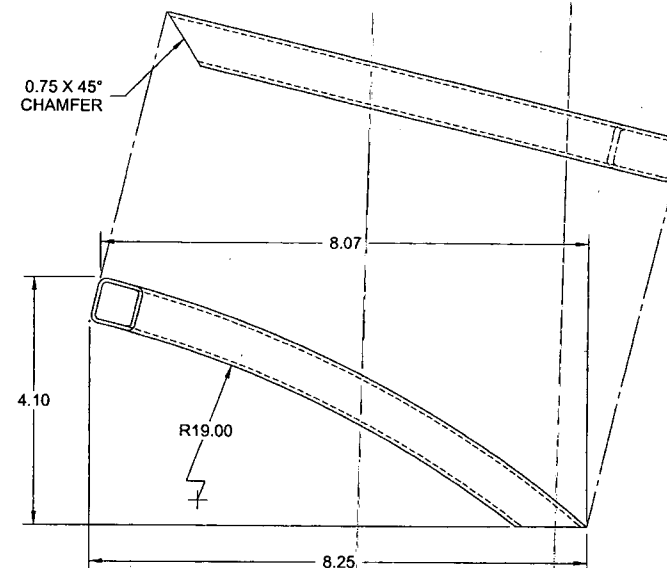
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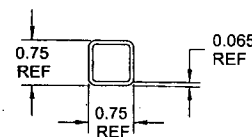
NOTE: Date & initial all entries



D2989-3 RIB



D2989-4 RIB



TYPICAL SECTION VIEW

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

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RELEASED
08/11/18 NW

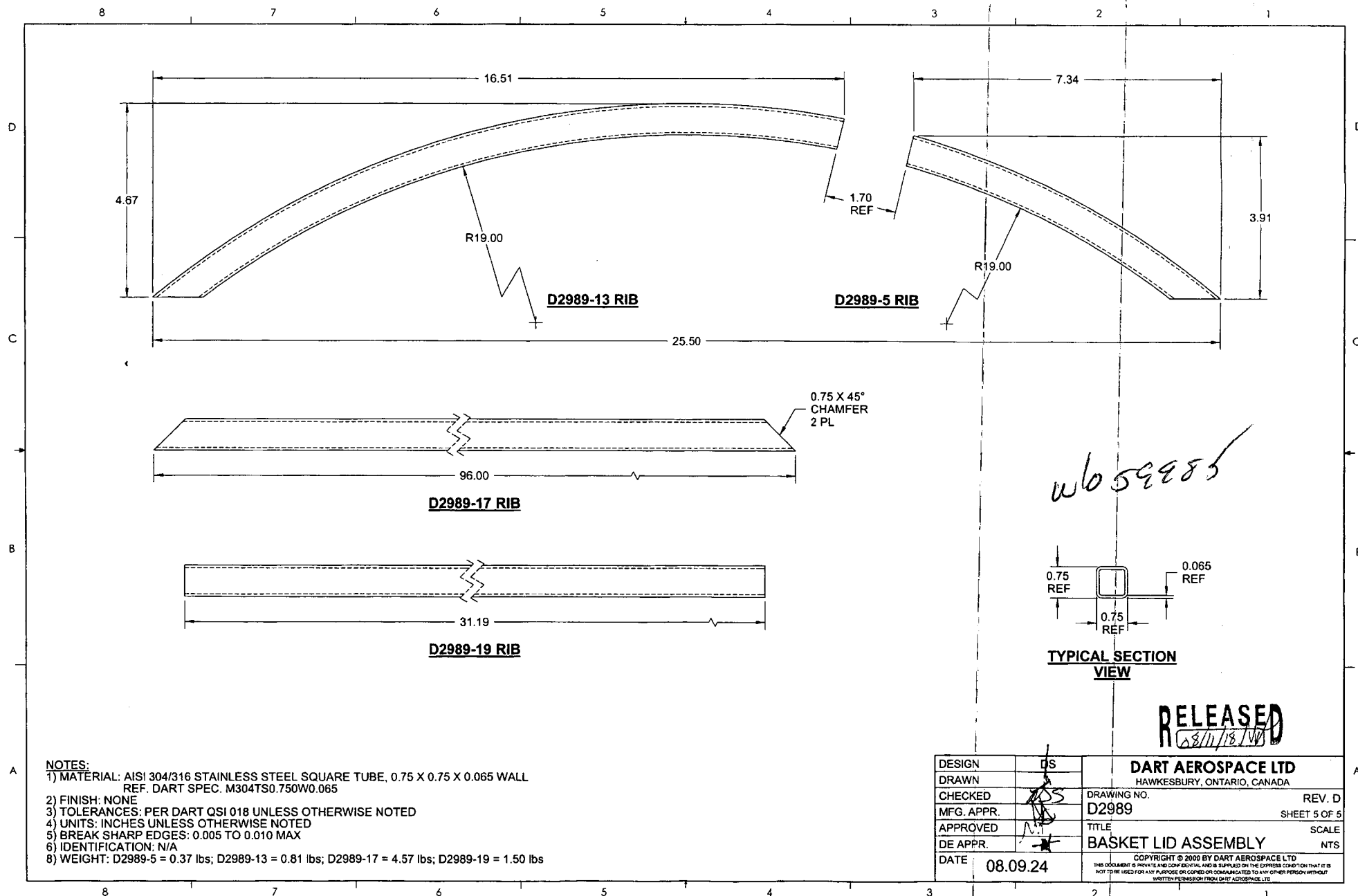
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